Work Order ID 101383

May-08-13 2:35:29 PM

101383

Item ID: D2581
Revision ID:
Item Name: Mounting Bracket

Accept *N900040100*

Setup **Start** *NS1*
Stop *NS2*

Start Date: 5/08/13 **Start Qty:** 20.00 *20*
Required Date: 5/14/13 **Req'd Qty:** 20.00 *20*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 13-05-08 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run **Start** *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2581	**Revision Nbr** Rev A1								
100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JET **Memo** 1-Cut as per Dwg D2581 Dwg Rev: A1 Prog Rev: A1 2-Deburr if necessary	0.00 0.00				20			DAS 05 8-89 13-05-14
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				20			DAS 05 8-89 13-05-14
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00 DAS 27 13-5-14				20			

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		________
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		________
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		________
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID **101383**

May-08-13 2:35:30 PM

101383

Item ID: D2581

Revision ID:

Item Name: Mounting Bracket

Accept *N900040100*

Setup Start *NS1*

Stop *NS2*

Start Date: 5/08/13 **Start Qty:** 20.00 *20*

Required Date: 5/14/13 **Req'd Qty:** 20.00 *20*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** ____ **Date:** ____ **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE **Memo**	0.00 0.00				20			SP 13/05/15
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00	13.5.15			20			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: WA004 **Memo** *****STOCK IN BASKET CELL*****	0.00 0.00				20X			SP 13-5-15

DQA: ________ Date: ______________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Part No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. ______	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 101383

May-08-13 2:35:30 PM

101383

Item ID: D2581 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Mounting Bracket **Stop** *NS2*

Start Date: 5/08/13 **Start Qty:** 20.00 *20* **Cust Item ID:**

Required Date: 5/14/13 **Req'd Qty:** 20.00 *20* **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______ **Run Start** *NR1*

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160*	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	**Memo**	0.00				13/5/17/			

MCJ 13-05-16

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

May-08-13 2:35:33 PM

T

Work Order ID: 101383

Parent Item: D2581

Parent Item Name: Mounting Bracket

101383
D2581

Start Date: 5/08/13 **Required Date:** 5/14/13

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP D01.07.17Added info to step 2SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA *M304S11GA* 304/316 0.125 Sheet		Purchased	No			100	sf	183.9300	0.0187 **	0.393684		wl 13.05.14	

Location	Loc Qty	Loc Code
MAT020	183.93	
122521	24.93	
124445	159	

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____________	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. ____________	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____________	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD	Work Order:	101383
Description: Mounting Bracket	Part Number:	D2581
Inspection Dwg: D2581 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.328	+0.006/-0.001	0.328	✓		V	JKM-01
Ø0.191	+0.005/-0.001	0.191	✓		V	
0.750	+/-0.010	0.759	✓		V	
3.596	+/-0.010	3.596	✓		V	
2.846	+/-0.010	2.844	✓		V	
1.995	+/-0.010	1.994	✓		V	
R0.250	+/-0.010	R0.250	✓		RG	

Measured by:	[signature]
Date:	13.05.14

Audited by:	[stamp] 27
Date:	13.5.14

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.23	New Issue	KJ/JLM [signature]	[signature]

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ________	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Part No. ________	Rework ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
NCR No. ________	Scrap ☐	Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
	Use-as-is ☐	Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
	Work Order Update ☐	Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

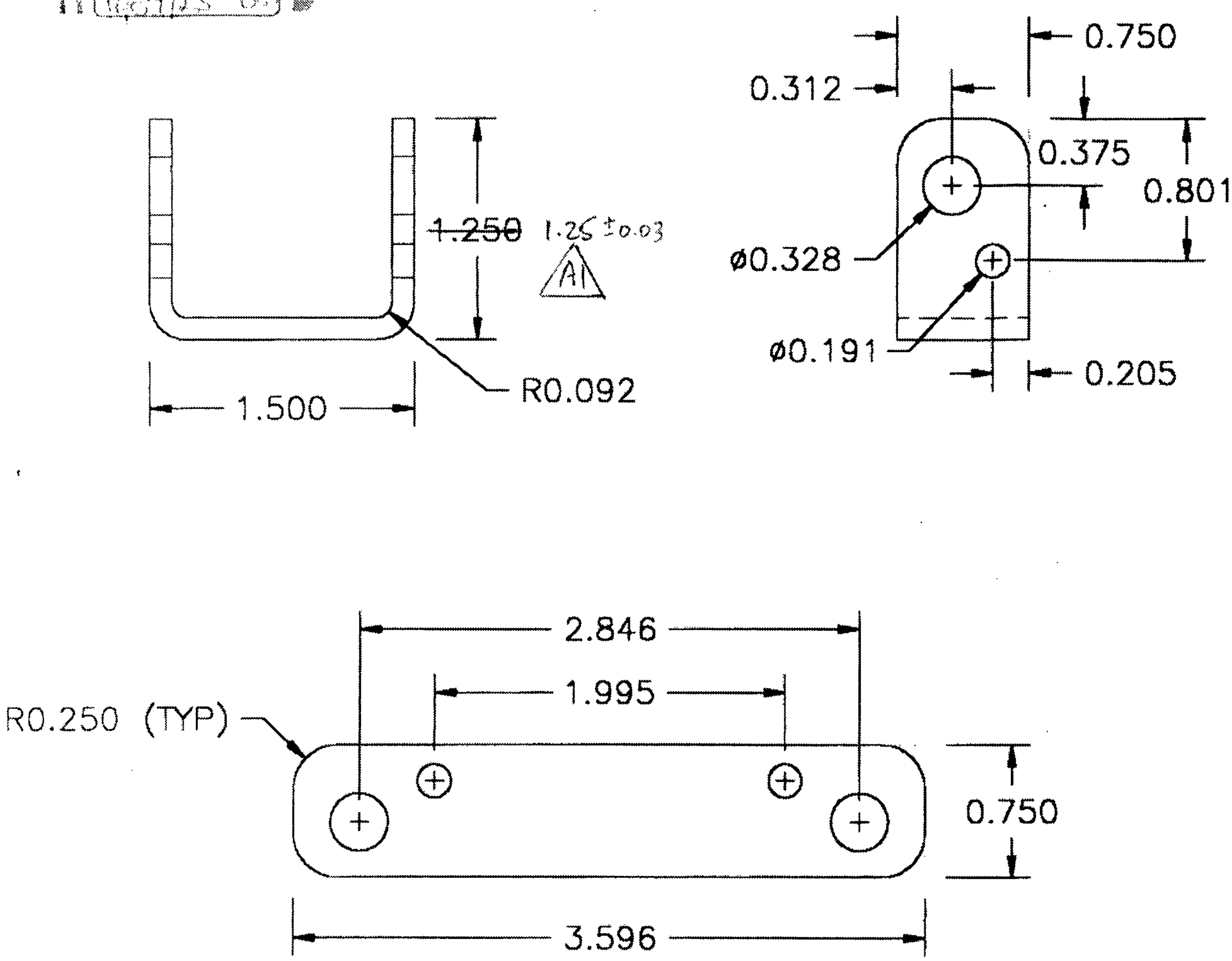
Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
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☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ________
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	________	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	________	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	________	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
MIKE M	MIKE M		
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	M M	D2581	SHEET 1 OF 1
DATE		TITLE	SCALE
96.06.27		MOUNTING BRACKET	1:1
A1	CP 04.05.14	CHANGE TOLERANCE ON 1.25 DIMENSION	

DART

QA COPY ISSUED

RELEASED



MATERIAL: 304/316 SS 0.125 THICK

NO_101383MG
13-05-08

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
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☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		